

Work Order ID 98778

March-25-13 9:59:46 AM

98778

Page 1

Item ID: D119-646-212 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Skidtube STD w/ Training Wearplates, RH
Start Date: 3/25/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/25/13 Req'd Qty: 1.00 ***1*** Customer:
Reference: RA111502 - REWORK ECN13-534

Approvals: Process Plan: ✓ Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| IIN-D119-646 | B |

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-646-212
CHG004

0.00

0.00

*SM7
B4.3*

| | | | | | |
|--|-----------------------|-----|-----------|--|--|
| DART Dart Aerospace Ltd. 1270 ABERDEEN ST HAWKESBURY, ON, CANADA K6A 4K7 | | | | TO APPROVAL # 08-09 TEL: 1-613-632-5200 | |
| P/N | D119-646-212 | CHG | CHG003 | | |
| DESC | Skidtube STD, RH | STC | SR02024SE | | |
| LOT | B91623 | STC | | | |
| MODEL | Agusta A119/AW119MKII | STC | | | |
| PATENTS US #5735484, CA #2222184 EUROPEAN No. #0828555 | | | | MADE IN CANADA 02729-2 | |

102

102

HandFinish

Hand Finishing

Memo

PULL FROM RA111502
1 X D119-646-212 B91623 *CHG003*
REMOVE FED CAP, PUT ASIDE TO RE-INSTALL

0.00

0.00

1x - 6 - 13/03/26

104

104

Skidtubes

Skidtubes

Memo

COUNTERSINK FWD MOST HOLES TO 0.385 X 100DEG ON BOTH SIDES
PER DSI 9594
DEBUR

0.00

0.00

DP 13-3-27

B98778 RH

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|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 105 *105* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 106 *106* HandFinish Hand Finishing | Memo -RE-ALODINE AFFECTED AREAS -TOUCH UP WITH IMRON | 0.00 0.00 | | | | | | | |
| 107 *107* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | |

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 108 | | 0.00 | | | | | | | |
| *108* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | REPLACE FWD CAP USING MS24694-C52 SCREWS SIKAFLEX B <u>1112344</u> 13/06 | | | | | | | | |
| 109 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *109* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | ENSURE ORIGINAL KIT IS IN BOX | | | | | | | | |

1 BK of Jll 13/03/12

DAS 13/04/03

13/4/3
DAS 06 9-89

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|---------------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC4- 100% Inspect kits for completeness Memo | 0.00 0.00 | | SMD 13.4.3 | | 1 | | | |
| 130 *130* Packaging Packaging | Memo RE-PACKAGE USING NEW B/N @ CHG004 NEW LABELS AND DSI PAPERWORK REQ'D Identify and pack for shipping as per PPP D119-646-212 Location: _____ PPP rev: _____ | 0.00 0.00 | | | | | | | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

DAS
06

13/4/12

8

13/4/13

13-04-13

Picklist Print

March-25-13 9:59:45 AM

Work Order ID: 98778

Parent Item: D119-646-212

Start Date: 3/25/13

Required Date: 3/25/13

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
644 DD verf:JLM IPP Rev:B 12.09.12 as per ECN12-
IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM IPP
REV:D 13.03.20 raise to chg004 (ECN 13-534) DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D119-646-212 | | Manufactured | No | | | | Each | 0.0000 | | 1 | B91623 | | ✓ |
| Skidtube STD w/ Training Wearplates, RH | | | | | | | | | | | | | |
| MS24694-C52 | | Purchased | No | | | | Each | 182.0000 | | 2 | 13103126 | | |
| Screw | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

ST301

182

124291

82

124308

100

X2

PA 111552

Returned D119 skids for reworking

D119-646-212

Batch # B91623

CHG # 003

98778

☒ yes ☐ no

☐ ☒ X

Was the box the skid tube returned in damaged
if yes describ

☐ ☒ X

Was the skid tube damaged?
What was damaged

☐ ☒ X

Does it need to be repair and replaced

☒ RH ☐

Is the tube the correct part (LH/RH)

☒ X ☐

Is the "k" kit returned with the skid tube
if yes B# 91623 CHG003

☒ X ☐
☒ X ☐

Was the kit opened
Was it re verified

☒ X ☐
☒ X ☐

Test fit Saddles caerfully. Fwd & Aft
Do the Fit

WHAT RE WORK DO THEY NEED

☒ X ☐

Do the need Fwd cap holes counter sunk

☐ ☒ X

Do the need the extra ground handling holes installed

☐ ☒ X

Do they need Both

Inspected By _____

Date _____

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skid tubes using the DSI 9594-011 Kit to make the skid tubes compatible with the Agusta ground handling wheels. One kit modifies 2 skid tubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skid tubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skid tube with $\varnothing 0.500$ " (12.7 mm drill), and countersunk to $\varnothing 0.650 \times 100^\circ$, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to $\varnothing 0.385 \times 100^\circ$.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the $\varnothing 0.500$ holes center in the skid tube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skid tube surface.
- 2.8 Repeat steps 2.1 to 2.7 for opposite skid tube.

3.0 PART LIST

| Qty -011 | PART NUMBER | DESCRIPTION |
|-------------|----------------|--------------------------------|
| X | DSI 9594-011 | FWD GROUND HANDLING SPACER KIT |
| 4 | D2579 | CROSS BOLT SPACER |
| 4 | MS24694-C52 | SCREW |

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

| | | | |
|------------|--|---|--------------|
| B | ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS | DB | 13.02.20 |
| A | NEW ISSUE | RF | 12.02.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | DB | KENT, WA | |
| CHECKED | MB | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9594 | SHEET 1 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FWD GROUND HANDLING SPACER KIT | NTS |
| DATE | 13.02.20 | <small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

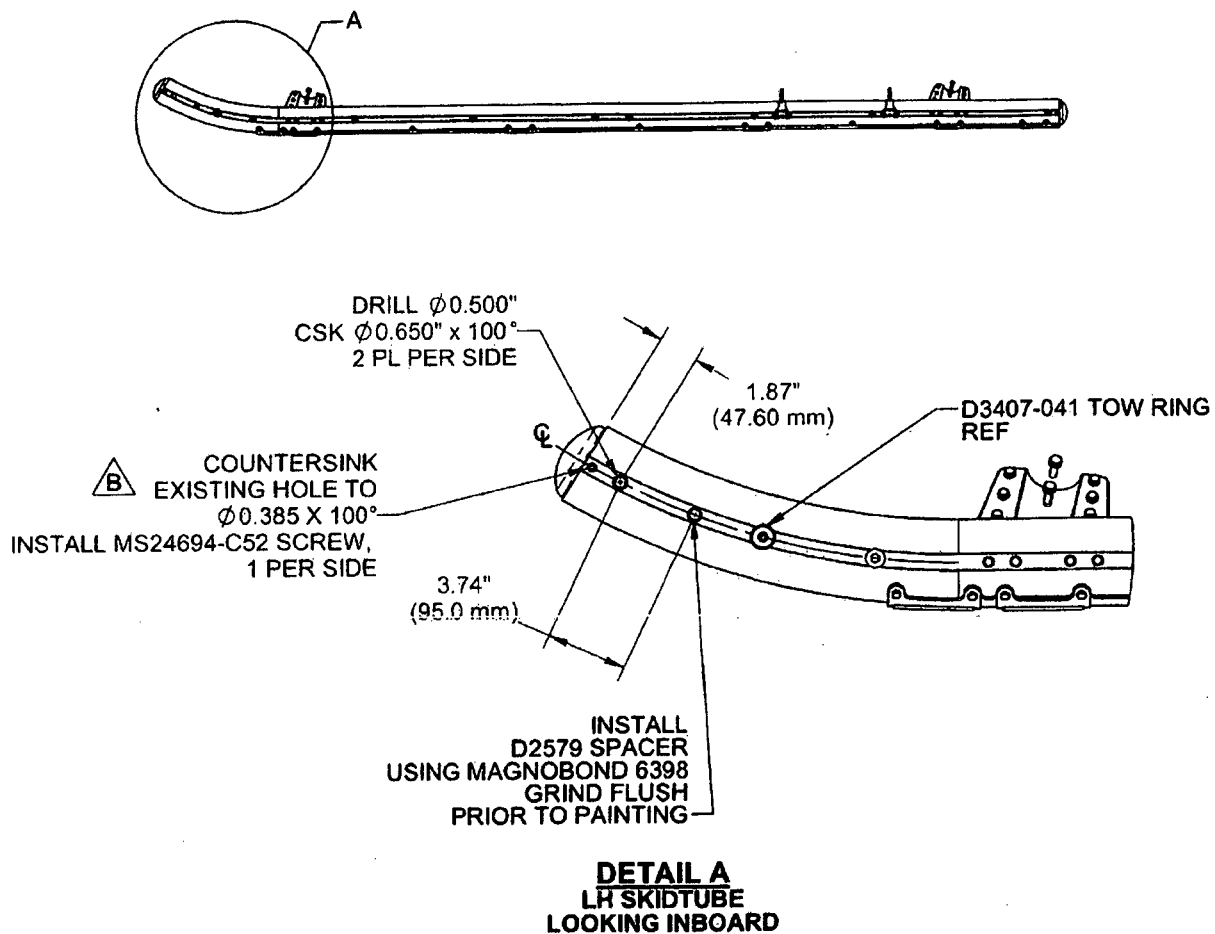


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE USA, INC | |
| DRAWN | DB | KENT, WA | |
| CHECKED | MB | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9594 | SHEET 2 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FWD GROUND HANDLING SPACER KIT | NTS |
| DATE | 13.02.20 | COPYRIGHT © 2012 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

Linda Lacelle

PAULSOZ

From: Eric Downing
Sent: March-22-13 3:50 PM
To: Linda Lacelle; Melanie Fauteux; Cathy Kerr
Cc: Patrick Smith; Sian Willems; Marc Bellavance; Lisa McMachen; Nigel Forbes
Subject: Returned D119 skids
Attachments: Check Sheet For retruned D119 skids B74791.xlsx; Check Sheet For retruned D119 skids B74793.xlsx; Check Sheet For retruned D119 skids B91588.xlsx; Check Sheet For retruned D119 skids B91559.xlsx; Check Sheet For retruned D119 skids B91623.xlsx; Check Sheet For retruned D119 skids B91624.xlsx

Linda / Mel

Work Scheme for the returned D119 skids from Agusta

- On 4 tubes the fwd. cap will need to be reworked as per the DSI
 - Remove and scrap both An3C-5A bolts and washers
 - Counter sink hole as per DSI
 - Touch up alodine as per QSI005
 - Touch up powder coat as per QSI005 with imron paint
 - Install screw per DSI
- On tubes with B74791 & B74793 this work is required
 - Remove all hard wear
 - Both end caps and all wear plates
 - Strip entire tube as per QSI 005
 - Locate both FWD holes as per DSI & ECN Drill as per drawing
 - Install cross bolt spacers as per DSI
 - Weld as per QSI004 A/R _____
 - Buff welds and deburr
 - Counter sink FWD end cap holes
 - Re alodine tube as per QSI 005
 - Re powder coat tube as per QSI005
 - Re wing-wak as per QSI005
 - Re assemble as per Drawing and per DSI

98774
98775
98776
98777
98778
98779

Thanks

Eric Downing
QC Corrdinator
T: 1-613-632-5200 ext 223
C: 1-613-363-9375
F: 1-613-632-5246
www.dartaero.com
Edowning@Dartaero.com